



# Flux Cored Wire



## Code & Specification

ASME SFA/AWS A5.20 E71T-1C

## Description

**BLUME<sup>®</sup> E71T-1C** is an all position flux cored wire designed for optimum performance when using 100% CO<sub>2</sub>, shielding. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads. Fillet contour is flat too slightly convex with equal leg lengths and uniform sidewall wetting. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity for X-ray soundness. This wire is formulated to produce 20% less fume, minimal spatter and improved impact properties over conventional E71T-1 wires.

## Shielding Gas

Carbon Dioxide (CO<sub>2</sub>)

## Applications

**BLUME<sup>®</sup> E71T-1C** is designed for all position single and multi-pass welding of low and medium carbon steels.

## Mechanical Properties

	As-welded
Yield Point, MPa	490 - 590
Tensile Strength, MPa	540 - 620
Elongation, %(L=4d)	24 - 33

## Charpy V-Notch Impact Properties

Testing Temp.	As-welded (J)
0°C (32°F)	70 - 100
-18°C (0.4°F)	50 - 75
-29°C (-20°F)	30 - 50

## Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	S	P~
0.03 - 0.08	0.90 - 1.40	0.30 - 0.80	≤ 0.03	≤ 0.03

## Suggested Welding Parameters (DC+)

Diameter	Flat		Vertical-up		Overheard	
	Volts	Amps	Volts	Amps	Volts	Amps
1.2mm (.045")	23 - 30	150 - 290	22 - 26	150 - 210	23 - 26	150 - 250
1.6mm (1/16")	25 - 34	180 - 400	21 - 27	180 - 250	22 - 27	180 - 310

## Packaging

15 kgs (33 lbs) [Net Weight] Plastic spools with OD = 270mm (11")

## Approvals



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